



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18560-3
Job Sheet 188717



Part No: RBT18560-3

Job Qty: 8 pcs

Part Name: Ring



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/14/19

Job Tracking No:

Due Date: 2/7/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG RBT18560 Rev 4 IPP Rev A 17.11.13 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	8 pcs	2/7/19	2/7/19	0.00	0.80	Bandsaw - 1		
120	SL-2500Y - B4B	8 pcs	2/7/19	2/7/19	0.00	2.67	SL-2500Y -1 - B4B		JK
150	QC 2	8 pcs	2/7/19	2/7/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		JK
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 38		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		

DAS
10
9-89

275



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 832-5200
Email: sales@dartero.com
www.dartaerospace.com

Container No: S146814



Part: RBT18560-3

Job No: 188717

Serial No/Batch: S146814

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 01/22/19

151 QC 8	8 pcs	2/7/19	0.00 0.00	QC 2 - 8	
				QC 8 - 12	
				QC 8 - 14	Ink 19/01/24
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 38	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	J
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
160 QC 5	8 pcs	2/7/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	NIR
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 38	
				QC 5 - 42	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
170 Outsource - 12 - Black Oxide	8 pcs	2/7/19		GRO002-VC	5 CT 19-01-B5
180 Packaging 2-1 - Receive - B4B	8 pcs	2/7/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	J FEB 06 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	

				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
190 QC 6	8 pcs	2/7/19	0.00 0.00	QC 6 - 38	
				QC 6 - 42	
				QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
					DAS FEB 06 2019 68 9-89
200 Packaging 3-1 - Stock - B4B	8 pcs	2/7/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
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				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
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				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	

Plex 1/14/19 2:19 PM dart.lacelle.linda

230 QC 21 - SA

8 pcs

2/7/19

0.00 0.00

QC 21 - SA - 21

QC 21 - SA - 70

Part Op 100 - Bandsaw - Cut blanks to 1.25"

Descriptions: 120 - MORI SL2500Y LATHE - 1-Machine as per folio FB730 FOLIO REV: AA DWG REV: 4 2-
Deburr

150 - QC2- Inspect parts off machine FAI/FAIB

151 - QC8- Inspect parts - second check

160 - QC5- Inspect part completeness to step on W/O

170 - -Issue P/O to Groupe Altech; PO 042398 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of
Conformity is required

180 - Receive & Inspect for Damage & Mat'l Certs

190 - QC6- All purchased or subcontracted products

200 - Identify as per dwg & Stock Location: _____

230 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-A513-T-2.625W0.250	A513 Seamless Alloy Steel Round Tubing 2.625"dia. x 0.250" .8800 ft (.11 ea)	100-Bandsaw		
	Wall	- 1		<u>5012943</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MT-A513-T-2.625W0.250	1	14	0

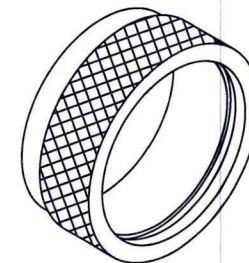
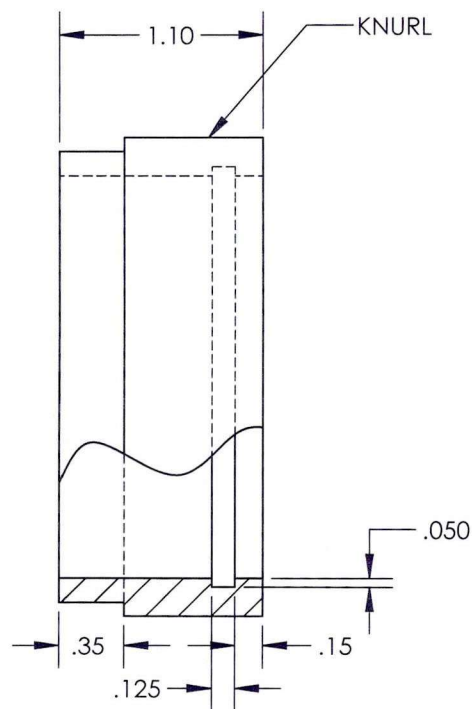
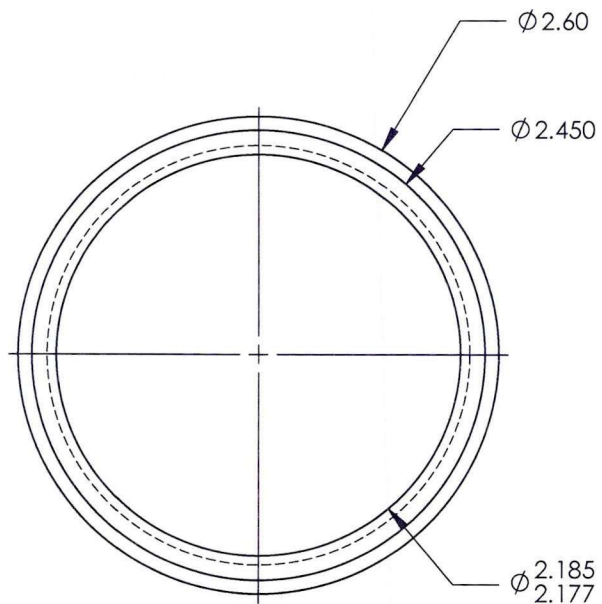
MAT009-A

Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



SHOP COPY
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WITHOUT NOTICE
WORK ORDER

NO. 188717 MJS
19-01-135

(-3)
RING

DART AEROSPACE	
TITLE ENGINE/GEARBOX SEAL PULLER	
DWG NO. RBT18560-3	REV 4
MAT'L DOM HEAT TREAT	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ± 1/16
FINISH BLACK OXIDE	.XXX ± .005 .XX ± .01 .X ± .1
SPEC	ANGLES ± 5° SURFACES = 125√
DRAWN BY: COLE	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED:	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR:	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR:	USED ON MODEL
APPROVED: WEIL	SEE SHT 1
SCALE 1:1	DATE 5/2/2002
SHEET 3 OF 6	

DART AEROSPACE LTD		Work Order:	78877
Description: ENGINE/GEARBOX SEAL PULLER		Part Number:	RBT18560-3
⇒ -3 RING			
Inspection Dwg: RBT18560-3	Rev: 4	Page 1 of 1	

INSPECTION SHEET

[illegible]

Measured by:	<i>JK</i>	Checked by:		QC Inspector:	
Date:	<i>19-1-22</i>	Date:		Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042398



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO042398
PO Date: 1/25/19
Due Date: 2/1/19
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pynt Terms: Net 60
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	188959	RBE350A94-3700-A-05	Foot -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	2/1/19	40 pcs	0 pcs	40 pcs	\$2.80/pcs	\$112.00
2	188717	RBT18560-3	Ring -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	2/1/19	8 pcs	0 pcs	8 pcs	\$1.35/pcs	\$10.80



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PURCHASE ORDER

PO042398



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	187451	RBT18511	Main Rotor Stationary Swashplate Bearing Removal -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed	-	2/1/19	4 pcs	0 pcs	4 pcs	\$8.25/pcs	\$33.00
4	185000	RBE105-31702W23-9	Measuring Flange LH Assembly -Issue P/O to GROUPE ALTECH: P/O Black Oxide -Material type; 4140 -Certificate of Conformity is required	Firmed	-	2/1/19	2 pcs	0 pcs	2 pcs	\$1.85/pcs	\$3.70
Grand Total:										\$159.50	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 1/28/19 7:46 AM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(016312-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

016312 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
05-Feb-2019		Aman			042398 ✓			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	RBE350A94-3700-A-05 ✓ Rev.	RBE350A94-3700-A-05 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	40	40 ✓	0	0	0
2	RBT18560-3 ✓ Rev.	RBT18560-11 BLACK OXIDE FINISH MIL-C-13924C CLASS 1	OXIDE-BLACK CH	8	8 ✓	0	0	0
3	RBT18511 ✓ Rev.	RBT18511 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924S CLASS 1 APPLY A THIN LAYER WIPE OFF EXCESS	OXIDE-BLACK CH	4	4 ✓	0	0	0
4	RBE105-31702W23-9 ✓ Rev.	RBE105-31702W23-9 01 -OXIDE BLACK [OXIDE BLACK]	OXIDE-BLACK CH	2	2 ✓	0	0	0

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.